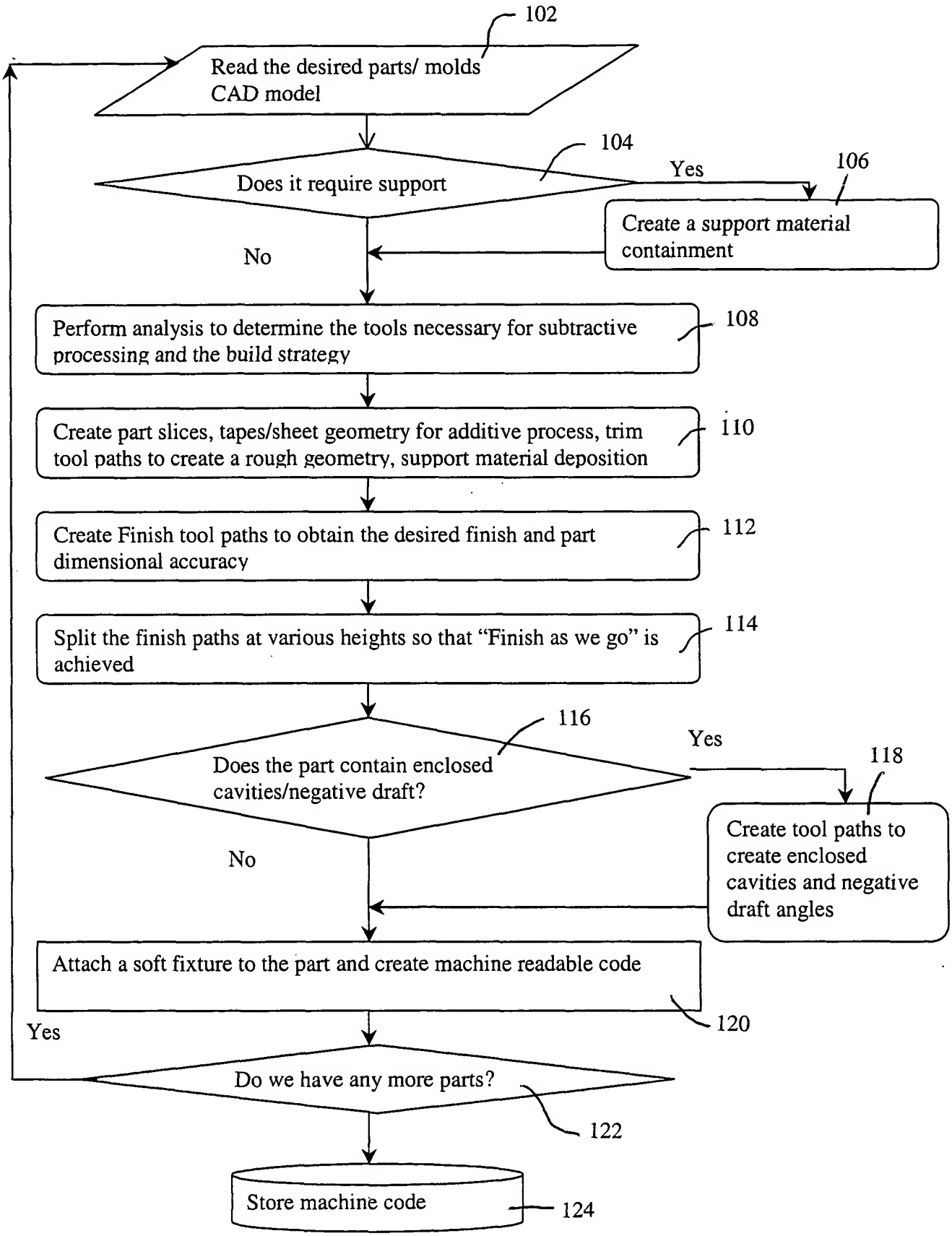
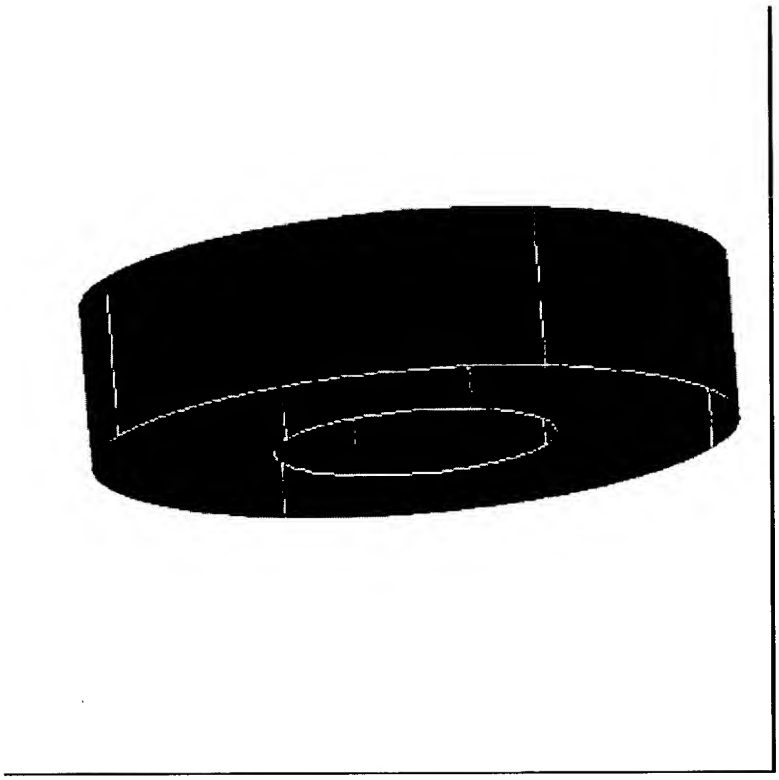
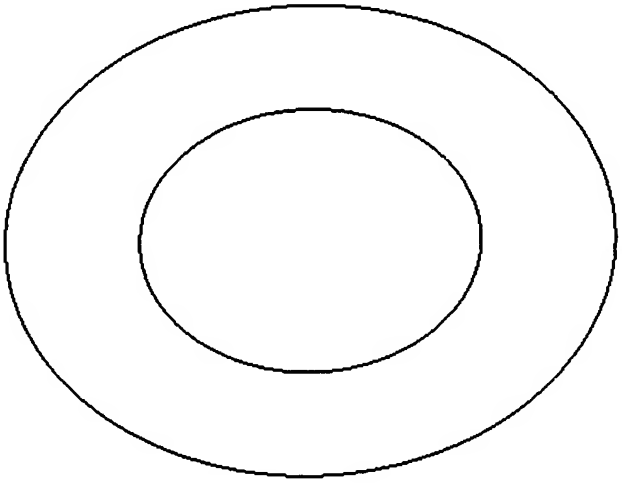

102
Read the desired parts/ molds CAD model
104
Does it require support
Yes
106
Create a support material containment
No
Perform analysis to determine the tools necessary for subtractive processing and the build strategy
108
Create part slices, tapes/sheet geometry for additive process, trim tool paths to create a rough geometry, support material deposition
110
Create Finish tool paths to obtain the desired finish and part dimensional accuracy
112
Split the finish paths at various heights so that "Finish as we go" is achieved
114
Does the part contain enclosed cavities/negative draft?
116
Yes
118
Create tool paths to create enclosed cavities and negative draft angles
No
Attach a soft fixture to the part and create machine readable code
120
Yes
Do we have any more parts?
122
Store machine code
124

Figure 1



Part



Slice

Figure 2

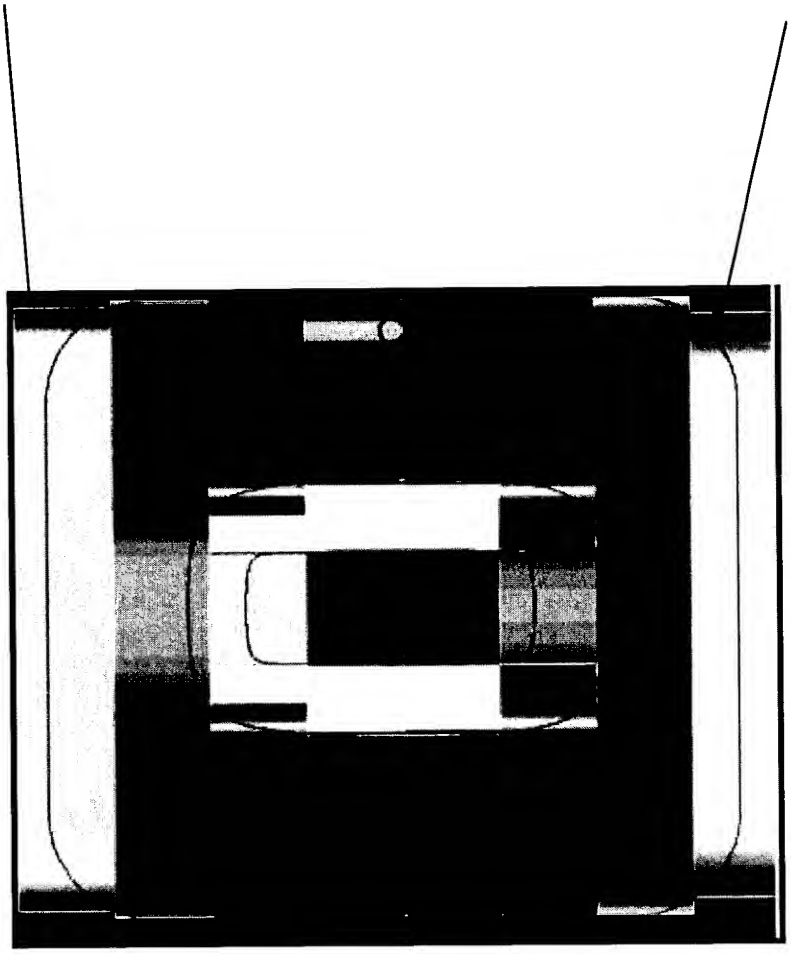


Figure 3

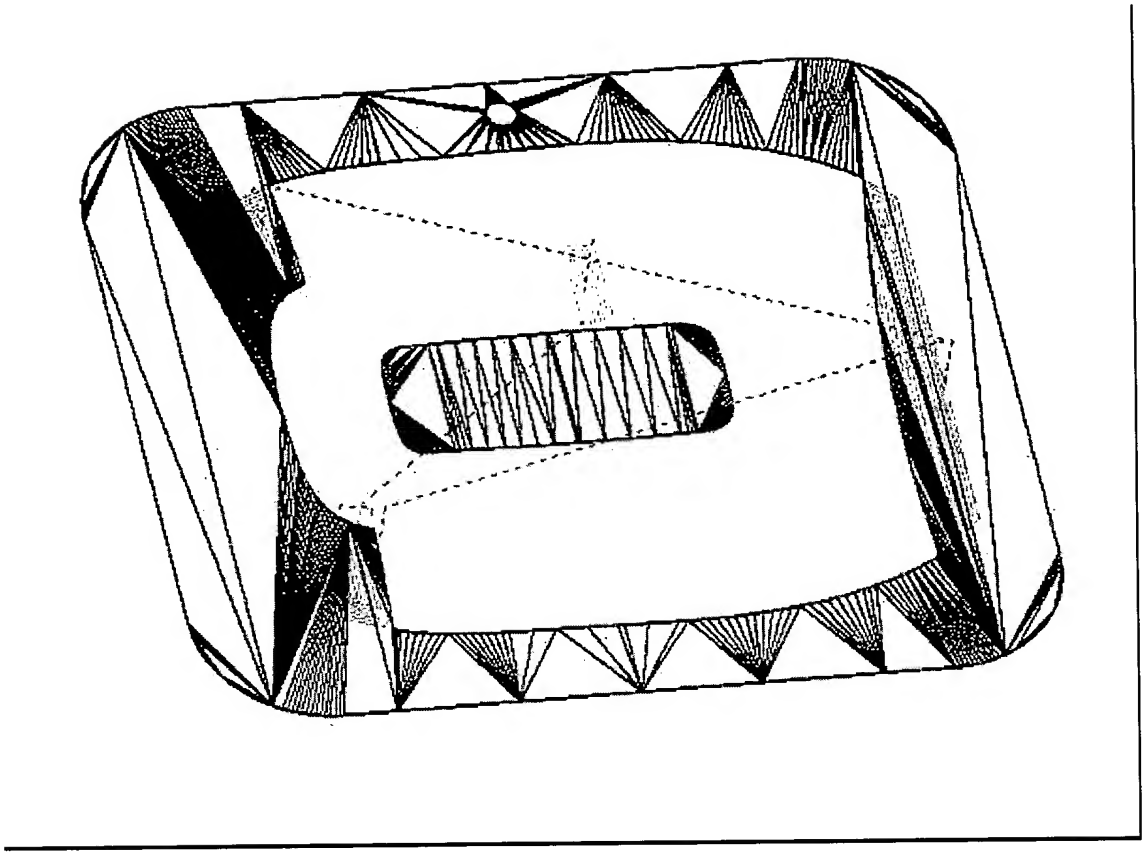


Figure 4

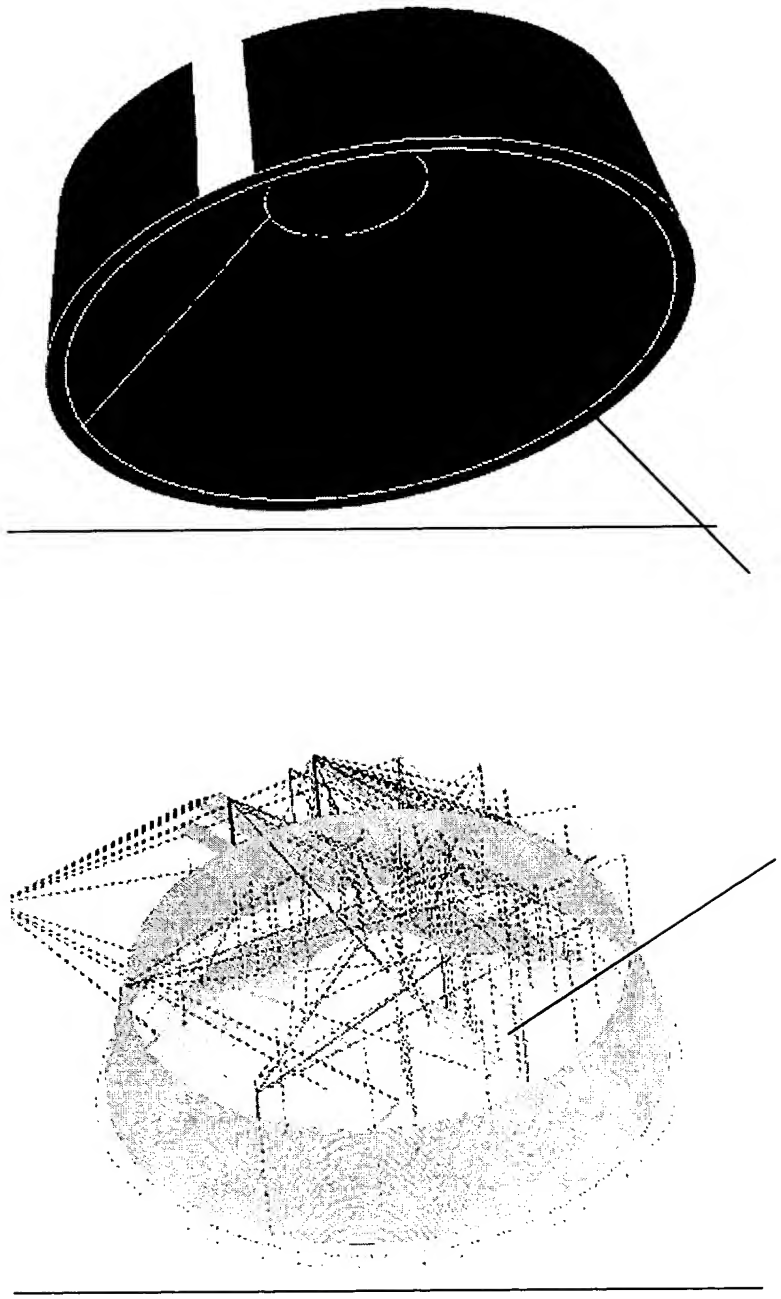


Figure 5

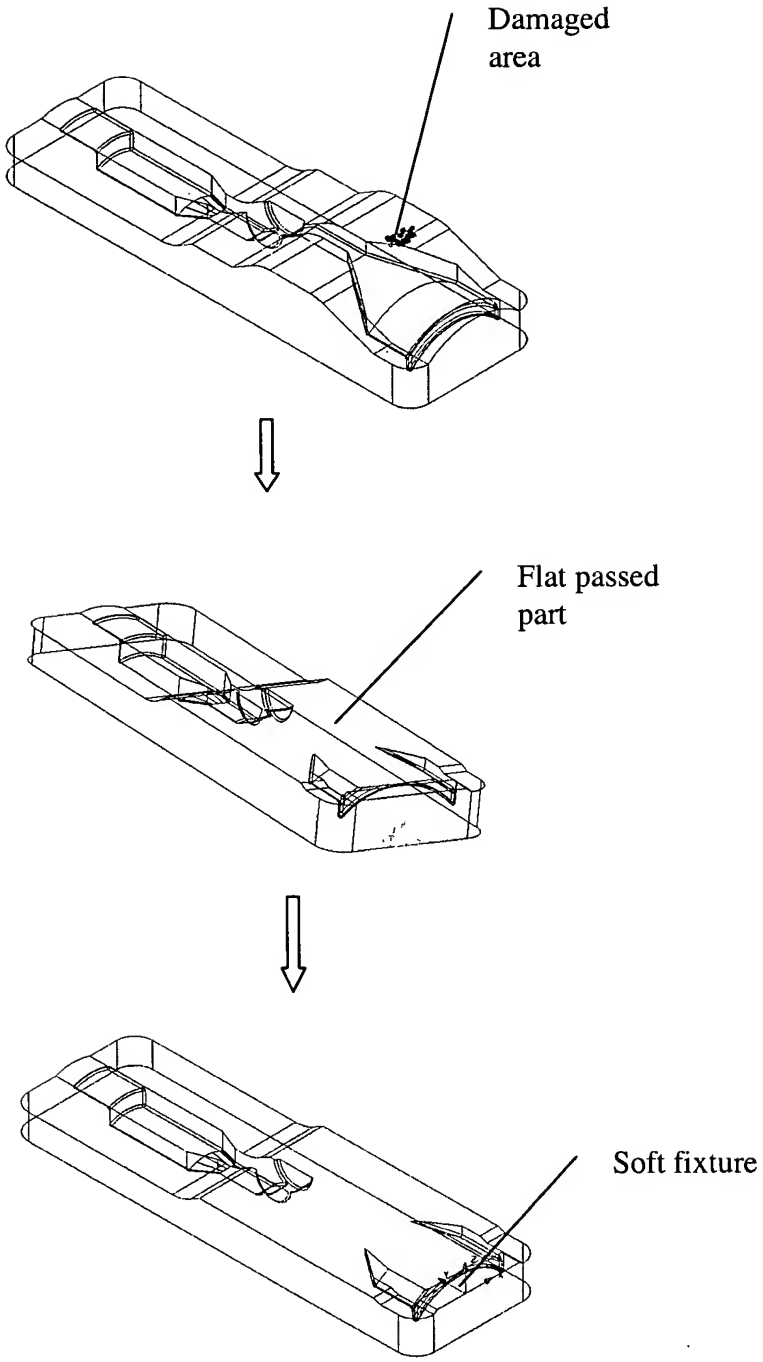


Figure 6